

Date: Monday, 17/11/2008 3:37:16 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 L WEB	
Job Number	: 43507		Part Number	: D26547	
Estimate Number	: 10722		Drawing Number	: D2654 REV E1	
P.O. Number	:		Project Number	: N/A	
This Issue	: 17/11/2008 S.O. No. :		Drawing Revision	: E1	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : SKIDTUBES		Due Date	: 24/11/2008 Qty: 4 Um: Each	
Previous Run	: 42633				
Written By	:				
Checked & Approved By	: JUL 08.11.19				
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:e 06.04.05 Added level21 EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26007140	EXT. "I BEAM" THICK
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick:		
Qty	Part Number	Description
1	D2600-7- 140	Web
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-7 as perDwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

3.0	QC5	INSPECT WORK TO CURRENT STEP
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Job Number: 43507		Part Number: D26547
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>RF 08/11/19 (4)</i>
6.0	PACKAGING 1 	PACKAGING RESOURCE #1 <i>11-11-1A</i>
7.0	QC21 	FINAL INSPECTION/W/O RELEASE <i>08/11/21 JJ</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		<i>MF 08-11-20</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries

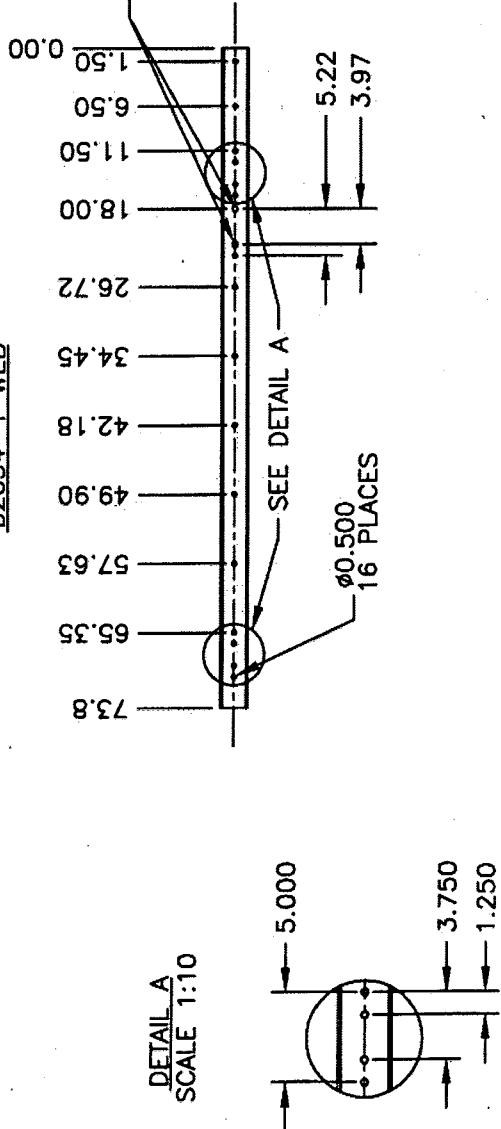
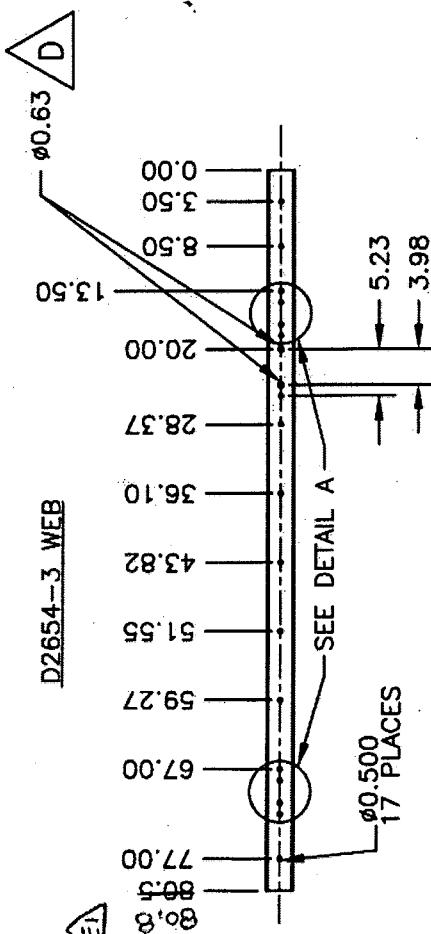
**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE WEB
04.05.26		SCALE 1:20

A 97.03.25 NEW ISSUE  
 B 97.06.26 ALTER HOLE PATRN., 0.500 WAS 0.438  
 C 97.10.29 CHANGED HOLE PATTERN  
 D 98.01.15 GHW HOLES CHANGED TO Ø0.63  
 E 04.05.26 CHANGE LENGTHS, REFORMAT  
 EI ~~IP~~ 04.08.94 PER TOOLING; 80.8 WAS 80.5

**RELEASED**

04.06.22

D2654-1 WEBD2654-3 WEB

MAKE FROM D2600-5-108 EXTRUSION  
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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 WORK ORDER  
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

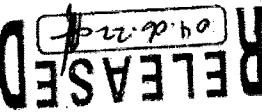
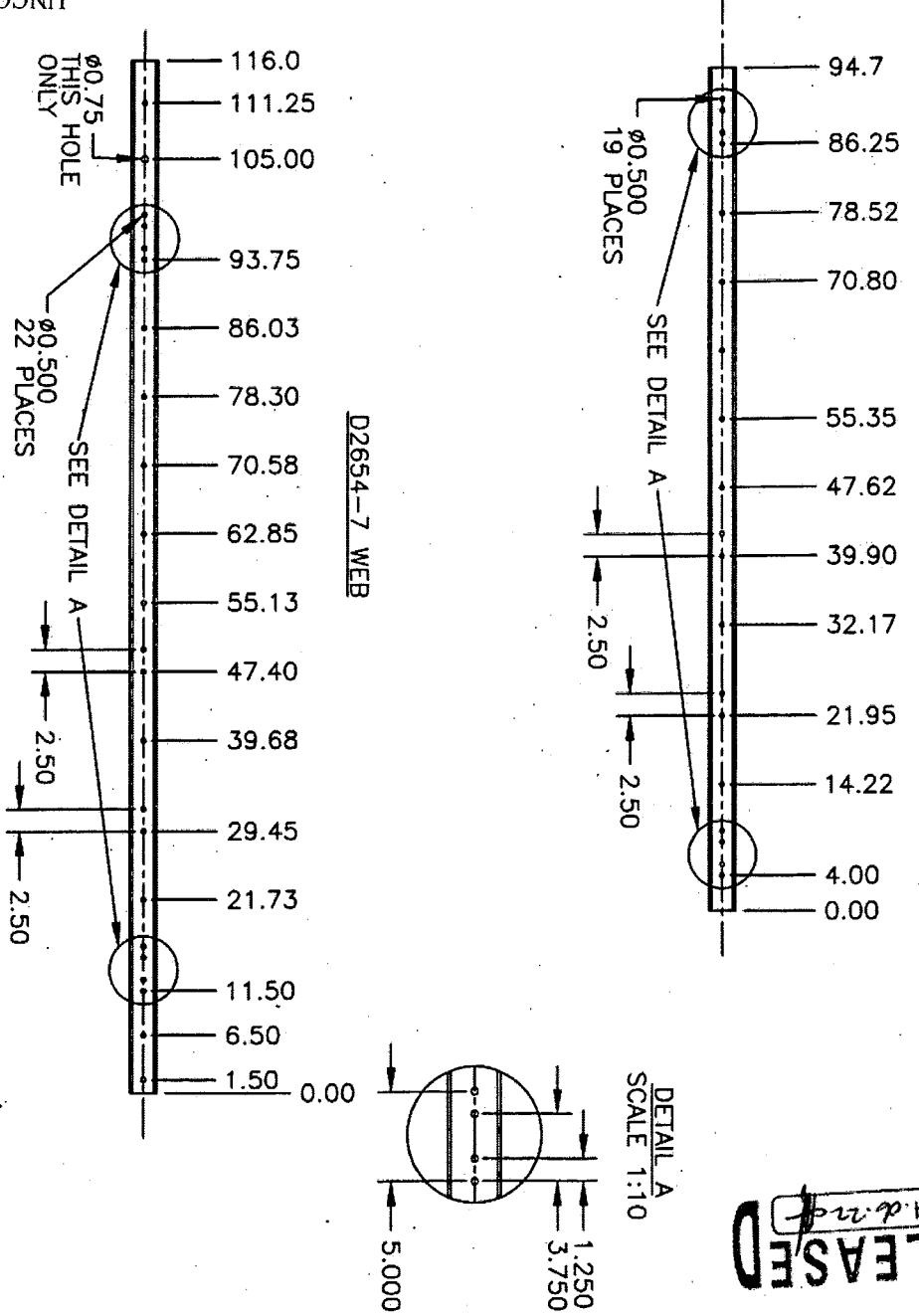
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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NO. 4350  
WORK ORDER  
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ENGINEERING  
RETURN TO  
SHOP COPY

MAKE FROM D2660-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	DRAWING NO.	D2654	REV. E
CHECKED	APPROVED		TITLE	SCALE	DATE
			WEB	1:20	04.05.26
			SHEET 2 OF 2		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries